

Ship Jan 12

Work Order ID 78035

\*78035\*

Page 1

December-28-11 8:09:55 AM

Item ID: D3914-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 28/12/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 12/01/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/12/28 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
100	Weld per dwg A/R S.S. rod Batch: <u>17884</u>	0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg D3914 ***inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

Cpl 12.01.05 1x  $\phi$

12.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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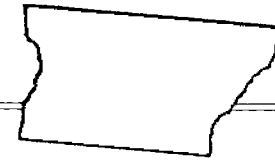
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*130*</b>									
Powdercoat	Memo	0.00							
Powder Coating									

\*\*\* mask sides of hinge prior to powdercoat\*\*\*  
 Start Time: 9:30  
 Oven Temperature: 320°F  
 Finish Time: 10:00

140	Wing Walk as per dwg QSI005 4.4 Batch 119094	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg  
 2- Install placard and label as per dwg  
 \*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label\*\*\*



12 01 06 (1)

12/01/09

1 BR 12-1-9

M 115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>D4032-041</u> 78028	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MF  
12-01-10

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# Picklist Print

December-28-11 8:09:59 AM

Page 1

Work Order ID: 78035

\*78035\*

Parent Item: D3914-041

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

89.0000

2

2

\*D2581\*

Mounting Bracket

\*\*

Pl 12.01.04

Location

Loc Qty

Loc Code

WA005

89

69739

1

70766

2

75280

9

77045

48

77523

29

100

Each

4.0000

2

2

D3914-1

Manufactured

No

\*D3914-1\*

Rib

\*\*

Pl 12.01.04

Location

Loc Qty

Loc Code

WA

4

74132

4

100

Each

4.0000

2

2

D3914-7

Manufactured

No

\*D3914-7\*

Rib

\*\*

Pl 12.01.04

Location

Loc Qty

Loc Code

WA006

4

75459

4

W/O:		WORK ORDER CHANGES					
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Page 2

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\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-3

Manufactured No

100

Each

24.0000

3

3

\*D4016-3\*

Hinge Half, Lid

\*\*

*PL12-01-04*

Location

Loc Qty

Loc Code

WA005

24

73630

6

*3*

74909

18

100

Each

10.0000

9

9

D4018-5

Manufactured No

\*D4018-5\*

Rib

\*\*

*PL12-01-04*

Location

Loc Qty

Loc Code

WA005

10

74917

10

*9*

100

Each

0.0000

1

1

D4020-5

Manufactured No

\*D4020-5\*

Mesh (350 Basket Long, Lid)

\*\*

*B75551 -> PL12-01-05*

D4021-3

Manufactured No

\*D4021-3\*

Data Plate

\*\*

*B73632 -> PL12-01-04*

Location

Loc Qty

Loc Code

WA005

2

73632

2

*1*

100

Each

4.0000

1

1

D4035-041

Manufactured No

\*D4035-041\*

Lid Rib Assembly, Fwd (350 Basket)

\*\*

*PL12-01-04*

Location

Loc Qty

Loc Code

WA006

4

76332

4

*1*

W/O:		WORK ORDER CHANGES					
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Page 3

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\*78035\*

Parent Item: D3914-041

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 28/12/2011

Required Date: 12/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

2.0000

1

1

\*D4035-043\*

Lid Rib Assembly, Aft (350 Basket)

\*\*

*PL 12-01-04*

Location

Loc Qty

Loc Code

WA006

2

74808

2

D2728-3

Manufactured No

140

Each

0.0000

1

1

\*D2728-3\*

Dart Logo label

\*\*

*115050.*

*1 BL 12-1-9.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

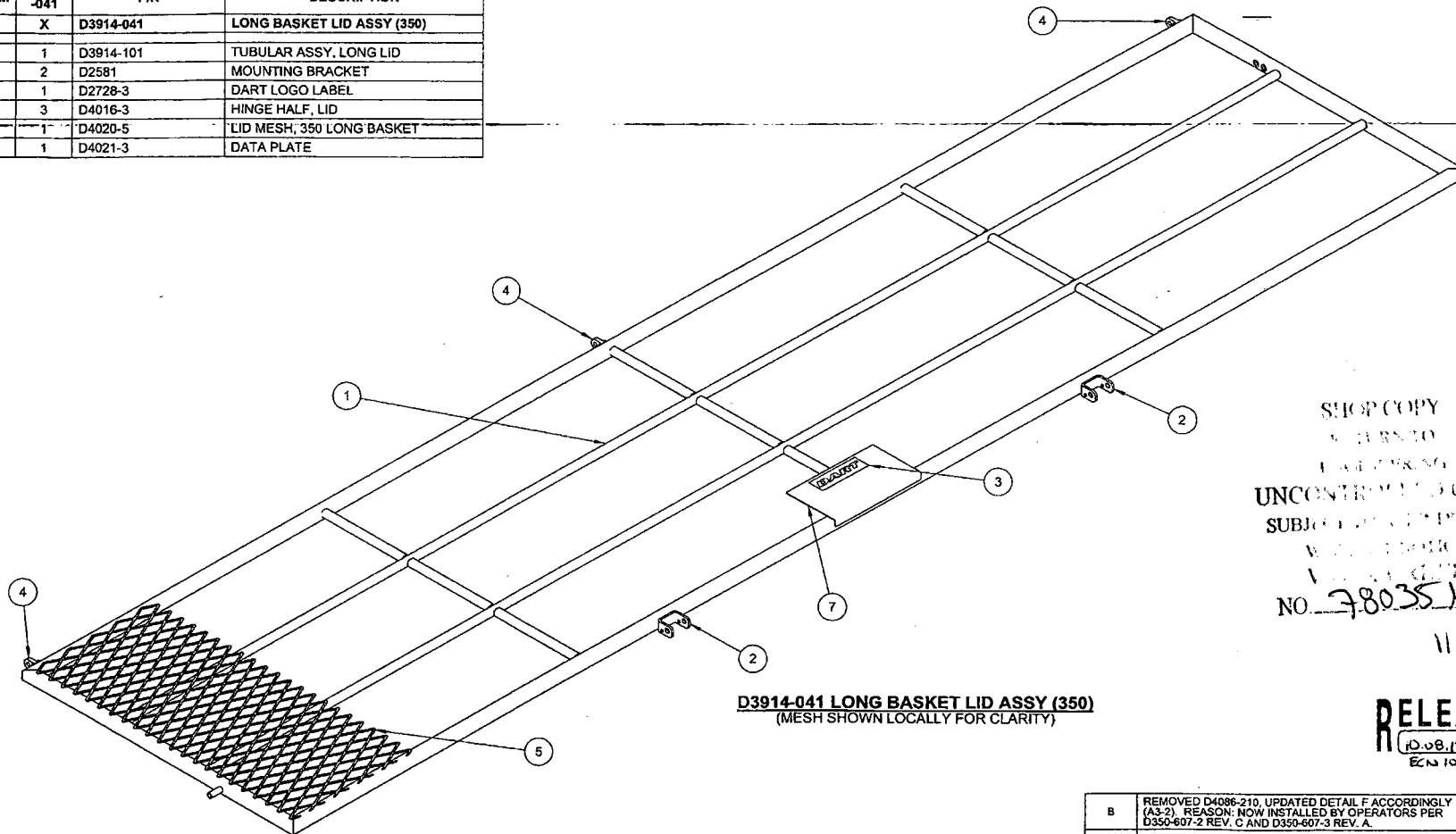
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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
DRAWING NO.  
UNCONTROLLED COPY  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
11/12/28  
NO. 78035 MCT

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3.2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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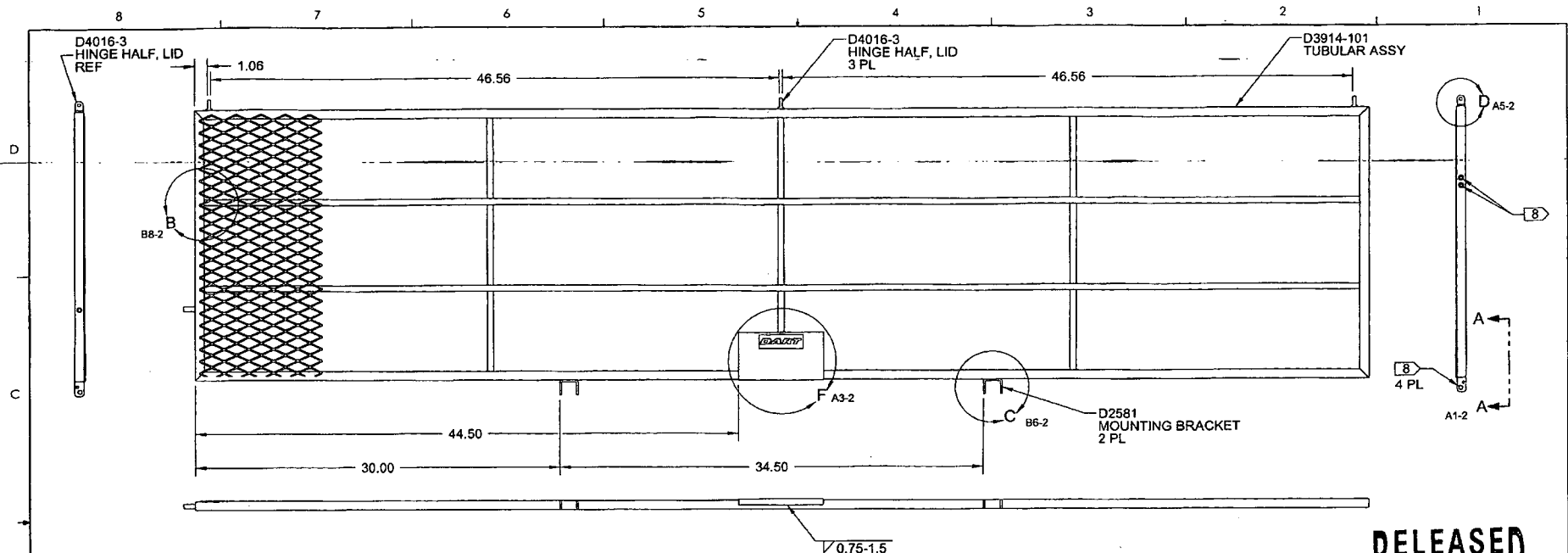
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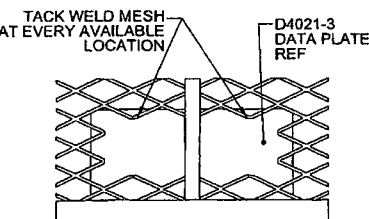
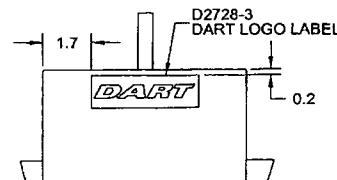
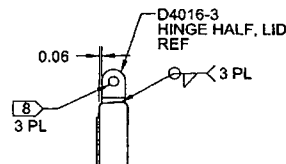
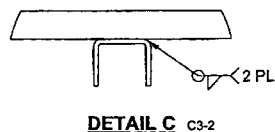
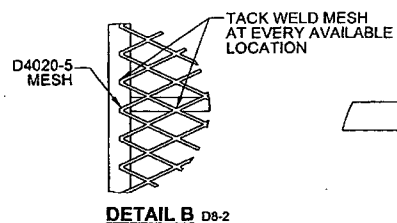
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78035



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**RELEASED**  
10.08.12 CP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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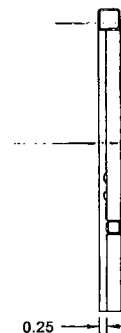
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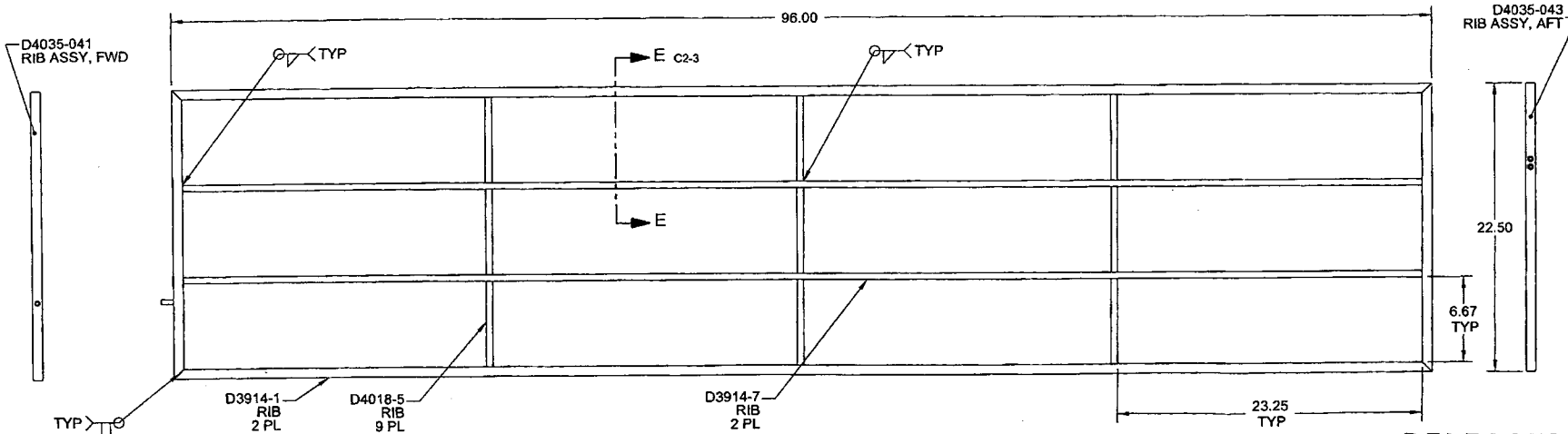


78035

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



(8) D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10-08-12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.10 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
  - 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AC	DRAWING NO. D3914	REV. B
MFG. APPR.	MD		SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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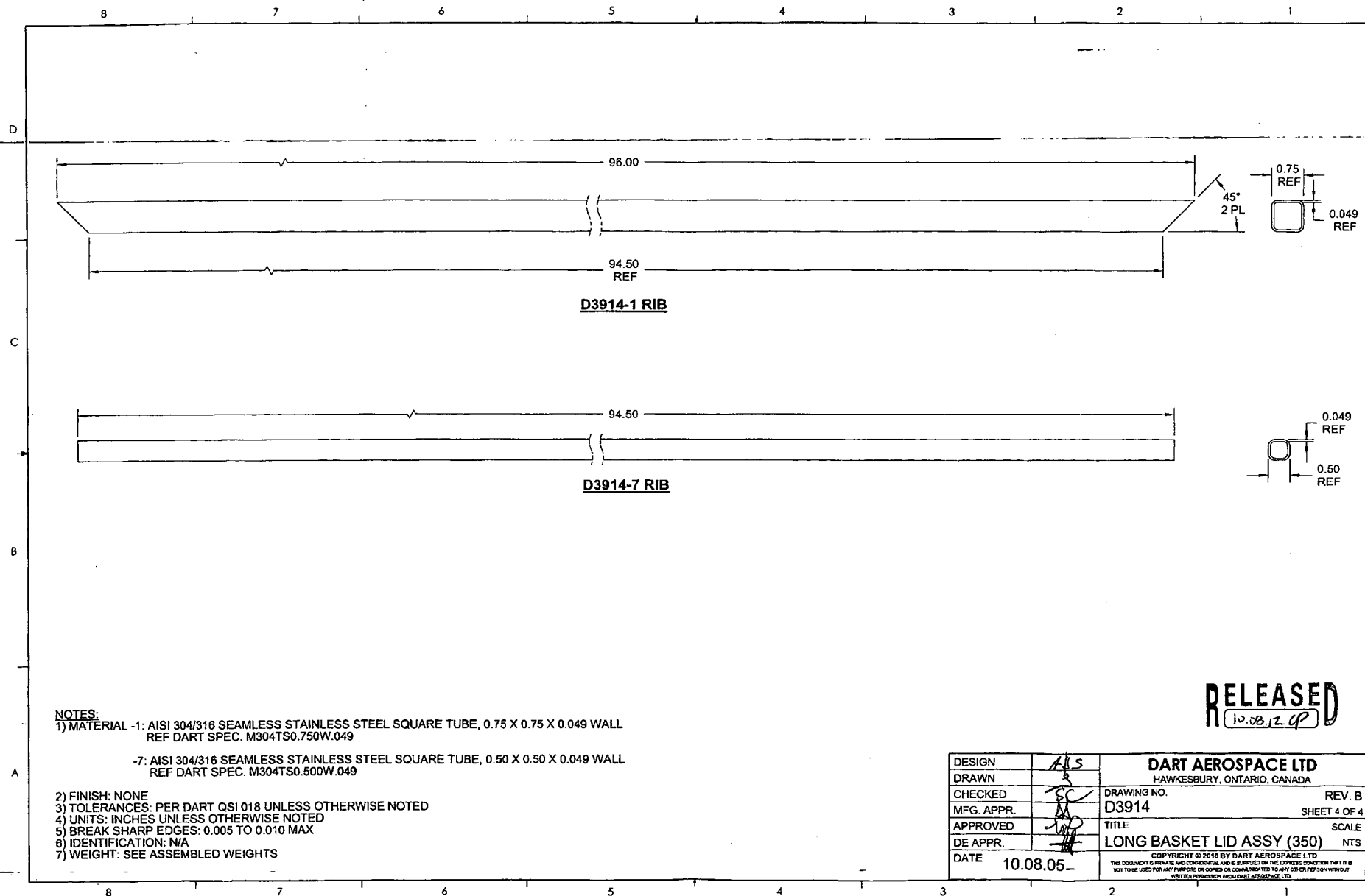
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**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

**RELEASED**  
10.08.12 CP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WDP	D3914	SHEET 4 OF 4
APPROVED	WDP	TITLE	SCALE
DE APPR.	WDP	LONG BASKET LID ASSY (350)	NTS
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